

Date: Tuesday, 08/08/2006 9:07:10 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28096
Estimate Number : 12451
P.O. Number : N/A
This Issue : 08/08/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 27654
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 06-06-15 JLM

Drawing Name : 350 SADDLE

Part Number : D35001
Drawing Number : D3500 PREL Rev.
Project Number : N/A
Drawing Revision : PREL
Material : N/A
Due Date : 15/08/2006

Qty: 32 Um: Each

8 ASAP

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6102013 6061-T6 7.0x6.5x2.0



Comment: Qty.: 1.0000 Each(s)/Unit Total: 32.0000 Each(s)
6061-T6 7.0x6.5x2.0
350 Saddle Billet
Batch: B27814

SA

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. SA Double check by: JG

- 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets
- 4-Deburr
- 5-Tumble to remove sharp edges.

SA 06.08.09

22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06.08.09

22

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JG / JG 06/08/09 8

22

Tuesday, 08/08/2006 9:07:10 AM
Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SADDLE

Job Number: 28096

Part Number: D35001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

SC 06/08/15

20

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06-08-22

21

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST359

06/08/23

22

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/23

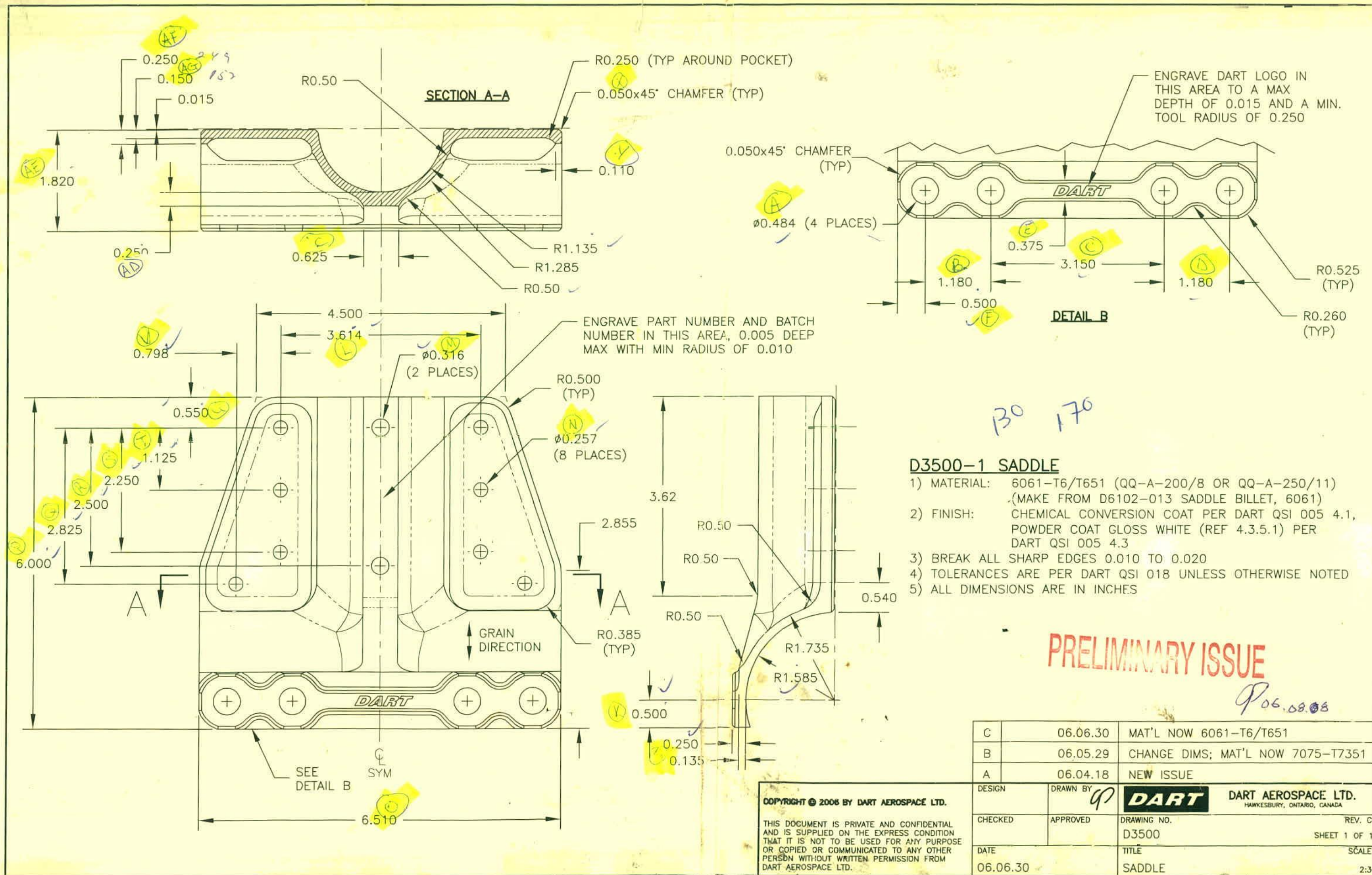
23

Completion



06.08.24

W 2008.23



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

PRELIMINARY ISSUE

P06.08.08

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	DRAWN BY <i>JP</i>	DART DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3500
DATE	06.06.30	TITLE SADDLE
		REV. C SHEET 1 OF 1 SCALE 2:3

COPYRIGHT © 2008 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

1.384 *1.400*

DART AEROSPACE LTD	Work Order:	
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500-1 Rev.a		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487	✓	✓	✓		
B	1.175	1.185		1.180	1.180	1.179	1.180		
C	3.145	3.155		3.150	3.150	3.149	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.376	.375	.375	.375		
F	0.490	0.510		.500	.501	.499	.499		
H	R.470	R.530		5.500	.500	.500	.500		
I	R1.575	R1.595		1.583	1.584	1.584	1.578		
J	0.240	0.260		.252	.251	.252	.254		
K	0.490	0.510		.500	.500	.500	.501		
L	3.609	3.619		3.613	3.614	3.613	3.614		
M	0.315	0.320		.320	✓	✓	✓		
N	0.256	0.262		.260	✓	✓	✓		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		5.999	5.997	5.997	5.998		
Q	2.820	2.830		2.826	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.549	.550	.550		
V	0.793	0.803		.797	.798	.798	.797		
W	R.240	R.260		1.250	.250	.250	.250		
X	0.040	0.060		.040	.050	.050	.05		
Y	0.100	0.120		.120	.120	.120	.120		
Z	0.352	0.372			can't find measurement				
AA	R1.125	R1.145		1.134	1.134	1.135	1.130		
AB	R.490	R.510		5.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.252	.252	.252	.255		
AE	1.810	1.830		1.820	1.821	1.823	1.817		
AF	0.240	0.260		.250	.251	.251	.246		
AG	0.140	0.160		.151	.152	.153	.148		
AH	0.130	0.170		.150	.151	.153	.153		
AI	0.130	0.170		.153	.153	.152	.152		
Accept/Reject									

Wall thickness for pores

Measured by: <u>J.L.</u>	Audited by: <u>J.G.</u>
Date: <u>06/08/10</u>	Date: <u>06/08/14</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	ec	

PRELIMINARY ISSUE

PRELIMINARY ISSUE

DART AEROSPACE LTD	Work Order:	
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500-1 Rev.a	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		/	/	/	/		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.374	.375	.375	.375		
F	0.490	0.510		.500	.500	.499	.499		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.578	1.585	1.586	1.581		
J	0.240	0.260		.252	.249	.248	.250		
K	0.490	0.510		.501	.500	.500	.500		
L	3.609	3.619		3.612	3.614	3.614	3.613		
M	0.315	0.320		/	/	/	/		
N	0.256	0.262		/	/	/	/		
O	6.500	6.520		6.509	6.508	6.509	6.509		
P	5.990	6.010		5.998	6.000	5.999	5.999		
Q	2.820	2.830		2.825	2.824	2.824	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.550	.550	.550		
V	0.793	0.803		.797	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.120	.120	.120	.120		
Z	0.352	0.372		can't find measurement					
AA	R1.125	R1.145		1.129	1.136	1.140	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.255	.250	.251	.250		
AE	1.810	1.830		1.816	1.817	1.818	1.815		
AF	0.240	0.260		.247	.248	.251	.248		
AG	0.140	0.160		.149	.149	.152	.149		
AH	0.130	0.170		.150	.149	.150	.149		
AI	0.130	0.170		.153	.150	.150	.150		
Accept/Reject									

Wall thickness for bores

Measured by:	J.L
Date:	06/08/11

Audited by:	J.G
Date:	06/08/11

Rev	Date	Change	Revised by	Approved
A		New Issue	ec	

PRELIMINARY ISSUE

PRELIMINARY ISSUE

DART AEROSPACE LTD	Work Order:	
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500-1 Rev.a	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		/	/	/	/		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.499	.499	.500	.500		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.582	1.583	1.586	1.585		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.500	.500	.501	.500		
L	3.609	3.619		3.613	3.614	3.614	3.613		
M	0.315	0.320		/	/	/	/		
N	0.256	0.262		/	/	/	/		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	5.998	5.999	5.999		
Q	2.820	2.830		2.825	2.824	2.824	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.249		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.549	.550	.551		
V	0.793	0.803		.797	.798	.798	.797		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.120	.120	.120	.120		
Z	0.352	0.372		can't find measurement					
AA	R1.125	R1.145		1.132	1.133	1.136	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.252	.253	.253	.251		
AE	1.810	1.830		1.815	1.818	1.822	1.818		
AF	0.240	0.260		.248	.250	.251	.251		
AG	0.140	0.160		.150	.151	.152	.149		
AH	0.130	0.170		.153	.152	.149	.151		
AI	0.130	0.170		.151	.151	.151	.151		
Accept/Reject									

Measured by: JL
Date: 06/08/11

Audited by: S.G
Date: 06/08/11

Rev	Date	Change	Revised by	Approved
A		New Issue	ec	

PRELIMINARY ISSUE

JUL 21 1921

DART AEROSPACE LTD		Work Order:
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500-1 Rev.a		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		/	/	/	/		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.500	.499	.501		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.586	1.584	1.5825	1.582		
J	0.240	0.260		.251	.251	.246	.249		
K	0.490	0.510		.501	.501	.501	.501		
L	3.609	3.619		3.613	3.614	3.613	3.614		
M	0.315	0.320							
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		5.999	5.999	6.000	6.001		
Q	2.820	2.830		2.824	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.546	.546	.546		
V	0.793	0.803		.797	.797	.797	.797		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.120	.120	.120	.120		
Z	0.352	0.372			Card find dimension				
AA	R1.125	R1.145		1.136	1.134	1.1325	1.132		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.250	.251	.254	.254		
AE	1.810	1.830		1.819	1.818	1.816	1.816		
AF	0.240	0.260		.249	.254	.246	.249		
AG	0.140	0.160		.149	.154	.149	.151		
AH	0.130	0.170		.152	.152	.151	.151		
AI	0.130	0.170		.151	.151	.152	.152		
Accept/Reject									

Measured by: <u>JL</u> / <u>SA</u>	Audited by: <u>S.G</u>
Date: <u>06/08/11</u> / <u>06.08.12</u>	Date: <u>06/08/14</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	ec	

PRELIMINARY ISSUE

PRELIMINARY ISSUE

DART AEROSPACE LTD	Work Order:	
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500-1 Rev.a		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		/	/	/	/		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.380	.380	.380		
F	0.490	0.510		.495	.496	.497	.499		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.586	1.585	1.584	1.584		
J	0.240	0.260		.252	.249	.251	.248		
K	0.490	0.510		.500	.499	.500	.500		
L	3.609	3.619		3.613	3.613	3.614	3.614		
M	0.315	0.320		/	/	/	/		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.516	6.518	6.510		
P	5.990	6.010		6.001	5.999	5.998	5.999		
Q	2.820	2.830		2.823	2.823	2.823	2.823		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.546	.546	.546	.548		
V	0.793	0.803		.797	.797	.797	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.120	.120	.120	.120		
Z	0.352	0.372							
AA	R1.125	R1.145		1.136	1.135	1.134	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.630	.630	.630	.630		
AD	0.240	0.260		.255	.254	.255	.254		
AE	1.810	1.830		1.820	1.818	1.818	1.818		
AF	0.240	0.260		.253	.250	.249	.250		
AG	0.140	0.160		.153	.153	.152	.153		
AH	0.130	0.170		.151	.152	.151	.151		
AI	0.130	0.170		.152	.150	.151	.151		
Accept/Reject									

Measured by: <u>SD</u>	Audited by: <u>J. E</u>
Date: <u>06.08.12</u>	Date: <u>06108114</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	ec	

PRELIMINARY ISSUE

УРЕТИМИВНА 1220E

DART AEROSPACE LTD	Work Order:	
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500-1 Rev.a	Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		✓	✓				
B	1.175	1.185		1.180	1.180				
C	3.145	3.155		3.150	3.150				
D	1.175	1.185		1.180	1.180				
E	0.365	0.385		.380	.380				
F	0.490	0.510		.495	.498				
H	R.470	R.530		.500	.500				
I	R1.575	R1.595		1.585	1.586				
J	0.240	0.260		.251	.246				
K	0.490	0.510		.500	.500				
L	3.609	3.619		3.614	3.614				
M	0.315	0.320		✓	✓				
N	0.256	0.262		.260	.260				
O	6.500	6.520		6.510	6.510				
P	5.990	6.010		6.000	6.000				
Q	2.820	2.830		2.825	2.825				
R	2.495	2.505		2.500	2.500				
S	2.245	2.255		2.250	2.250				
T	1.120	1.130		1.125	1.125				
U	0.540	0.560		.548	.547				
V	0.793	0.803		.797	.797				
W	R.240	R.260		.250	.250				
X	0.040	0.060		.050	.050				
Y	0.100	0.120		.120	.120				
Z	0.352	0.372							
AA	R1.125	R1.145		1.135	1.136				
AB	R.490	R.510		.500	.500				
AC	0.615	0.635		.620	.630				
AD	0.240	0.260		.254	.254				
AE	1.810	1.830		1.818	1.818				
AF	0.240	0.260		.250	.251				
AG	0.140	0.160		.153	.153				
AH	0.130	0.170		.152	.151				
AI	0.130	0.170		.152	.152				
Accept/Reject									

Measured by: <i>JD</i>
Date: <i>06.08.13</i>

Audited by: <i>5.6</i>
Date: <i>06/08/14</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	ec	

PRELIMINARY ISSUE

СЕРИИ ММВНН 1221Е